

3050



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DEVIATION
QTY 1

RB T101896-11

Job Sheet 178325



DL-SFWB

Part No: RB T101896-11

Job Qty: 12 ea

Part Name: Spindle Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT101896 Rev A IPP Rev A 18.03.27 New issue DP Verify DD/IPP Rev. B 18.05.24 New DWG update DP Verify DD

Ship Via:

SHIP
7-13
No
FAIL

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	6/18/18	6/18/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	12 pcs	6/18/18	6/18/18	0.00	6.00	MORI SL2500Y		
120	QC	12 pcs	6/18/18	6/18/18	0.00	0.00	QC2 Machining-4		
130	QC	12 pcs	6/18/18	6/18/18	0.00	0.00	QC8 Machining-4		
150	Outsource	12 pcs	6/18/18	6/18/18	0.00	0.00	Outsource13		
160	Packaging	12 pcs	6/18/18	6/18/18	0.00	0.00	Packaging2		
170	QC	12 pcs	6/18/18	6/18/18	0.00	0.00	QC6		
180	Packaging	12 pcs	6/18/18	6/18/18	0.00	0.00	Packaging3-1		
190	QC21-SA	12 Ea	6/18/18	6/18/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FC122 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - Issue P/O to GROUPE ALTECH. P/O _____ Zinc plate, ASTM B633 TYPE 2 SC2 - Color yellow - Material
type: Certificate of Conformity is required

DAS
53

JUL 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-R2.000	AISI 4140 Round Bar	6.9960 ft (.583 ea)	90-Start up Operation	51810

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-R2.000	7	14	0

M303 R2.000

Part Specifications

Specifications could not be found.



Container No: S091516



Part: RB T101896-11

Job No: 178325

Serial No/Batch: S091516

Revision: A

Inspector:

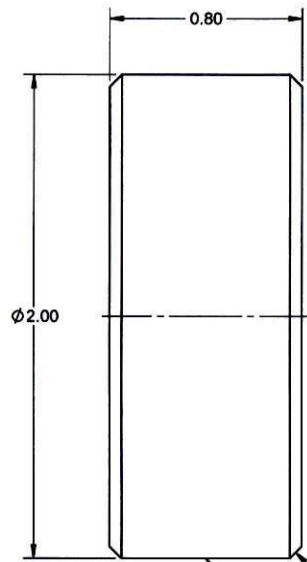
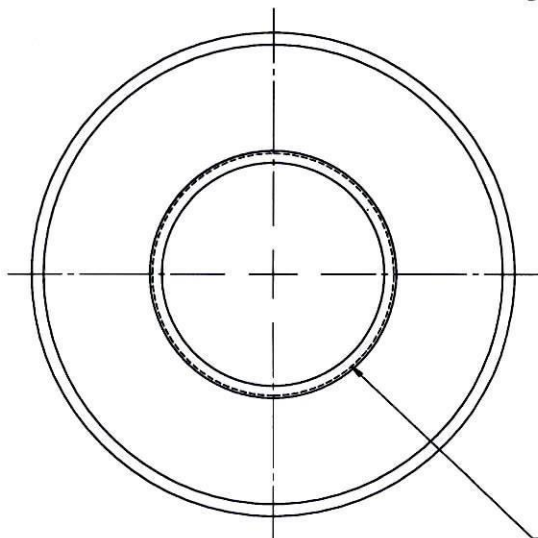
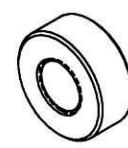
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 6/22/18 10:46 AM dart.logan.david

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 178325
20180622
2L



1-12 UNF-3B
 $\varnothing_{Min} .9148 \pm .005$

0.05 X 45° CMF
 4 PL
 MEDIUM DIAMOND KNURL

RB T101896-11 SPINDLE NUT

- NOTES:
 1) MATERIAL: 4140/4142 (28-32 RC)
 2) HEAT TREAT: N/A
 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 7) IDENTIFICATION: N/A

RELEASED	DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	KPT		
	CHECKED	ML	TOOL PART #	REV. A
	MFG. APPR.	DP	RB T101896	SHEET 6 OF 9
	APPROVED	<i>Mee</i>	TITLE	SCALE
	DATE	5/28/2018	M/R GRIP SPACING TOOL	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

DQ#: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>178325</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. <u>RBT101896-11</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No.		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval MLa

Description Work Order Deviation MAKE FROM 303/304/316/17-4 PH- H900-H1160 DO NOT ZINC PLATE APPLY ANTISEIZE TO THREADS * QTY 1 ONLY *	Disposition THIS DEVIATION IS ACCEPTABLE NO CHANGE TO FIT/FORM OR FUNCTION	Completed By <u>JULY 10/18</u>
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☒	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					